

Date: Monday, 05/03/2007 11:53:47 AM
 User: Linda Lacelle

Process Sheet

SPL/T

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30995
 Estimate Number : 10326
 P.O. Number :
 This Issue : 05/03/2007 S.O. No. :
 Prsh Rev. : NC
 First Issue : 01/03/2007 Type : MACHINED PARTS
 Previous Run : 29339
 Written By :
 Checked & Approved By :
 Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

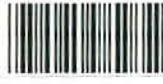
- 2

Drawing Name : LUG EXTRUSION
 Part Number : D2731
 Drawing Number : D2731 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : NA
 Due Date : 03/12/2007
 Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion  Comment: Qty: 0.0717 f(s)/Unit Total: 7.1715 f(s) Lug Extrusion D2423 Batch: 30062
2.0	BAND SAW	BAND SAW  Comment: BAND SAW Cut D2423 extrusion to .82" Batch: 30062.
3.0	PG	PURCHASING  Comment: PURCHASING Issue P/O BLKT0001 C 07/03/08 (100) Possible Supplier : Metec Machine per Drwg D2731 Rev.B
4.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Receive & Inspect for transit damage  J 07/06/12 (50)
5.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP  J 07/06/13 (50) counted.

Date: Monday, 05/03/2007 11:53:47 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 30995

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL 07-06-13 (50)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 104 144



(50) 07-06-14 (10)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EL 07/06/15 (50)



9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EL 07/06/15 (50)



10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EL 07/06/15 (50)



(50) 07/06/18

Job Completion



W 07-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/14	7	Too much print (fusing) new employee leaving dimples in 3 parts	Initial Sarah	-Sand lightly to remove dimples -Re-adsorb -Re-powdercoat	7/8/14	4	07/06/15	Sarah 7/8/14

NOTE: Date & initial all entries

Date: Thursday, 3/1/2007 11:34:05 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LUG EXTRUSION		
Job Number	30995			Part Number	D27317		
Estimate Number	10326			Drawing Number	D2731 REV B		
P.O. Number	:			Project Number	N/A		
This Issue	3/1/2007	S.O. No.	:	Drawing Revision	B		
Prsht Rev.	NC	Type	MACHINED PARTS	Material	:		
First Issue	/ /			Due Date	12/3/2007	Qty:	100
Previous Run	29339			Um:	Each		
Written By	<u>dk</u> 07.03.01						
Checked & Approved By							
Comment	Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: _____	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D2423 extrusion to .82"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 3/1/2007 11:34:05 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 30995

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30995
Description: Lug	Part Number:	D2731-7
Inspection Dwg: D2731	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

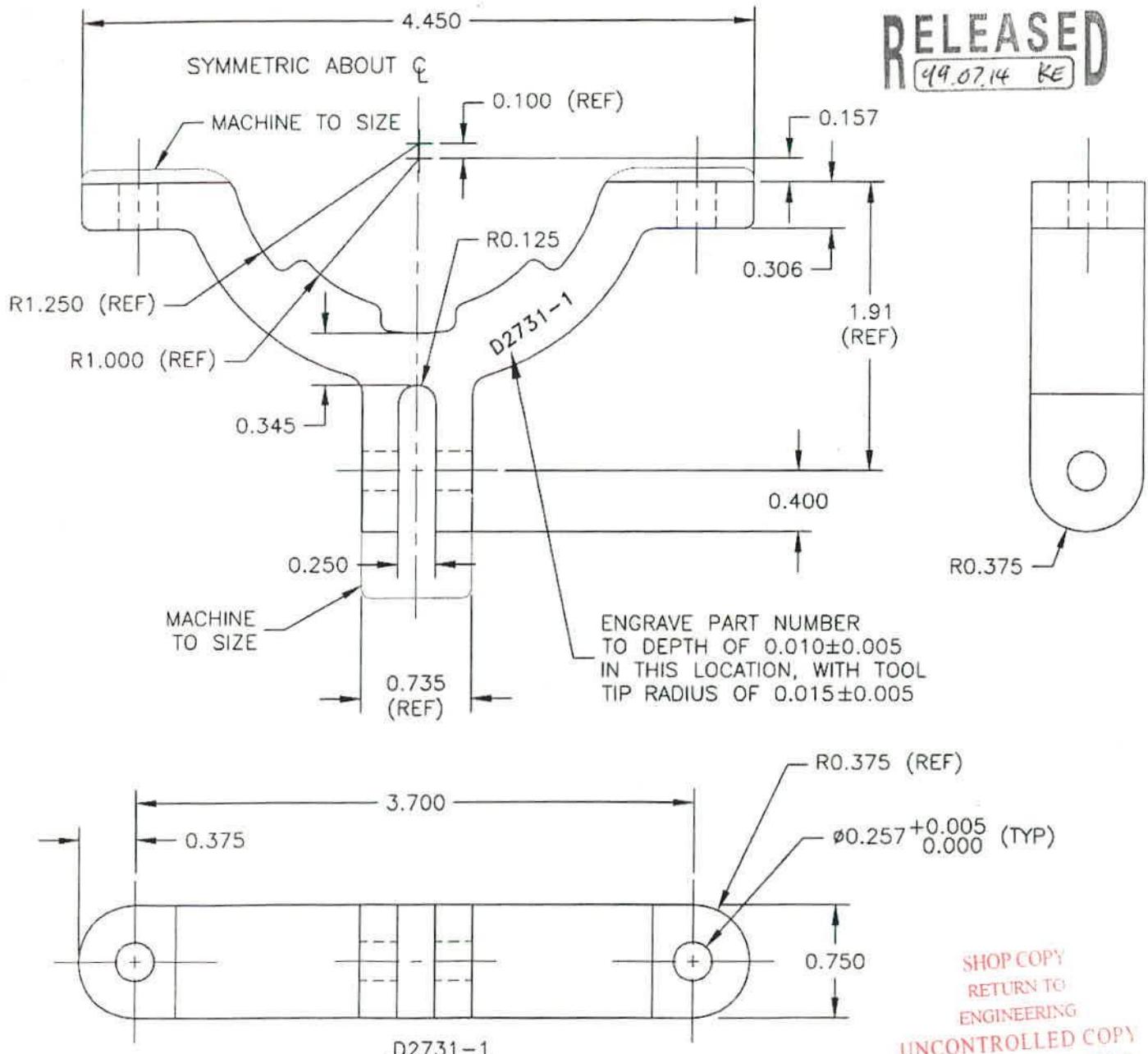
First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	
B	04.05.06	Dimension change	KJ/RF	



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>JK</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

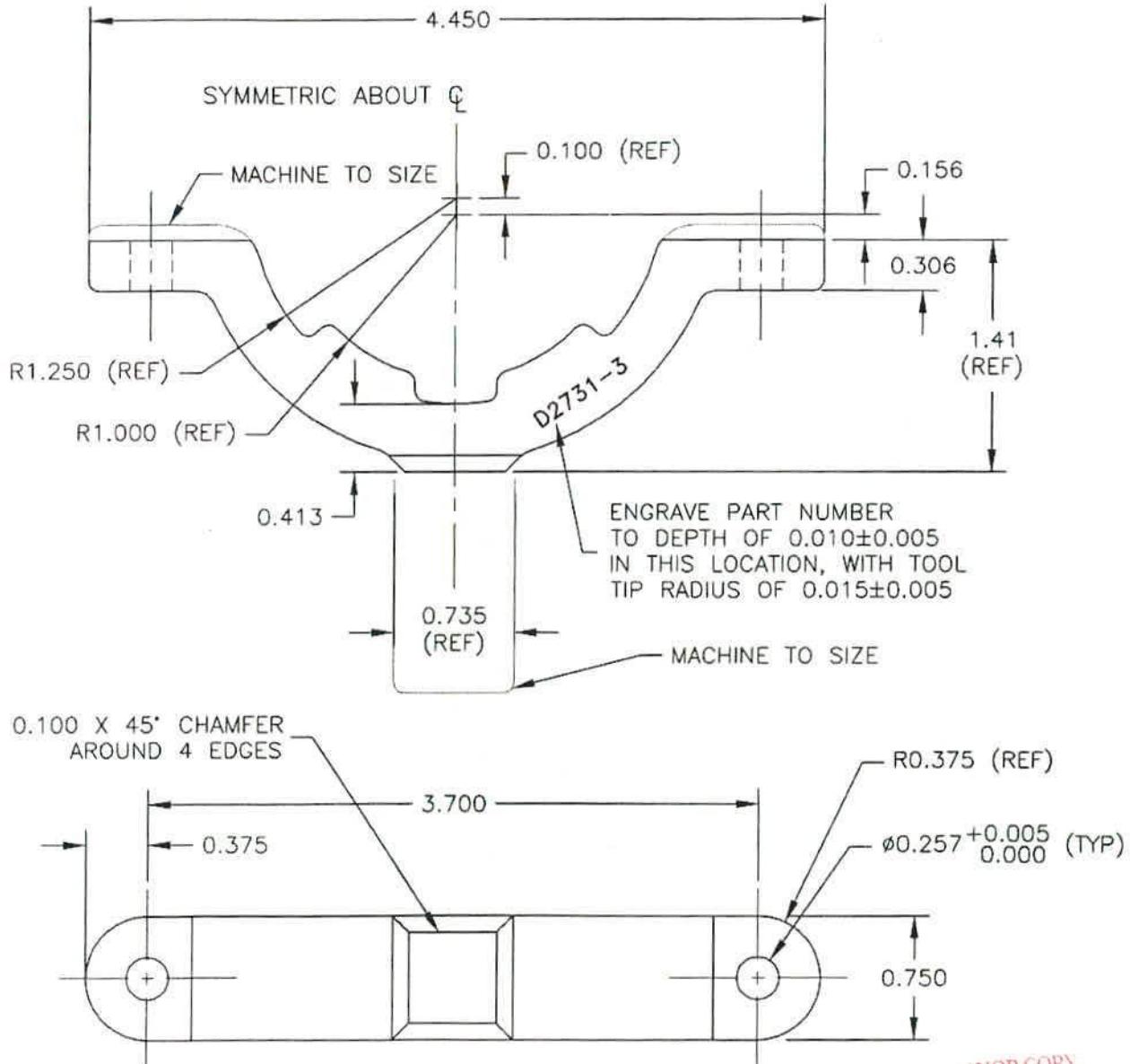


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 30995

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

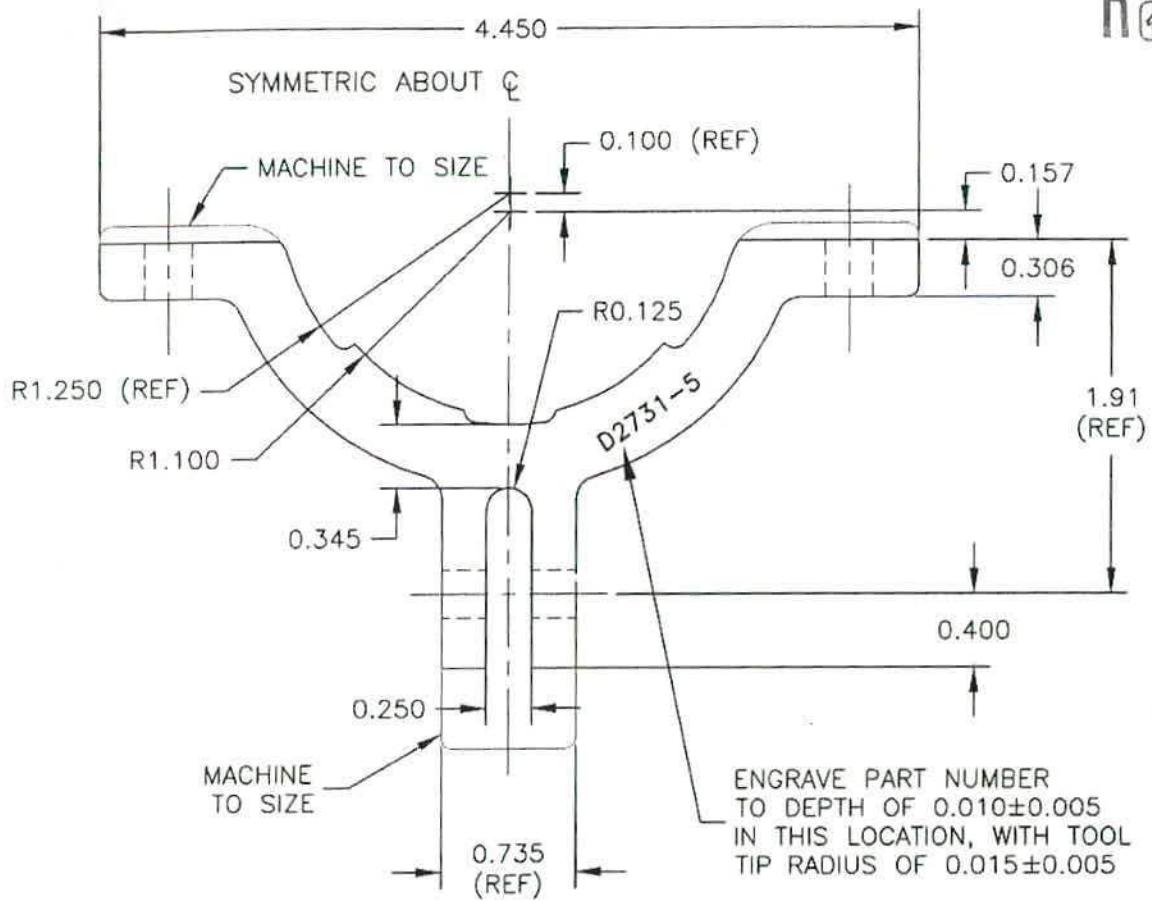
RELEASED
19.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 30995

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CHECKED <i>KE</i>	APPROVED <i>QS</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 3 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 *RE*

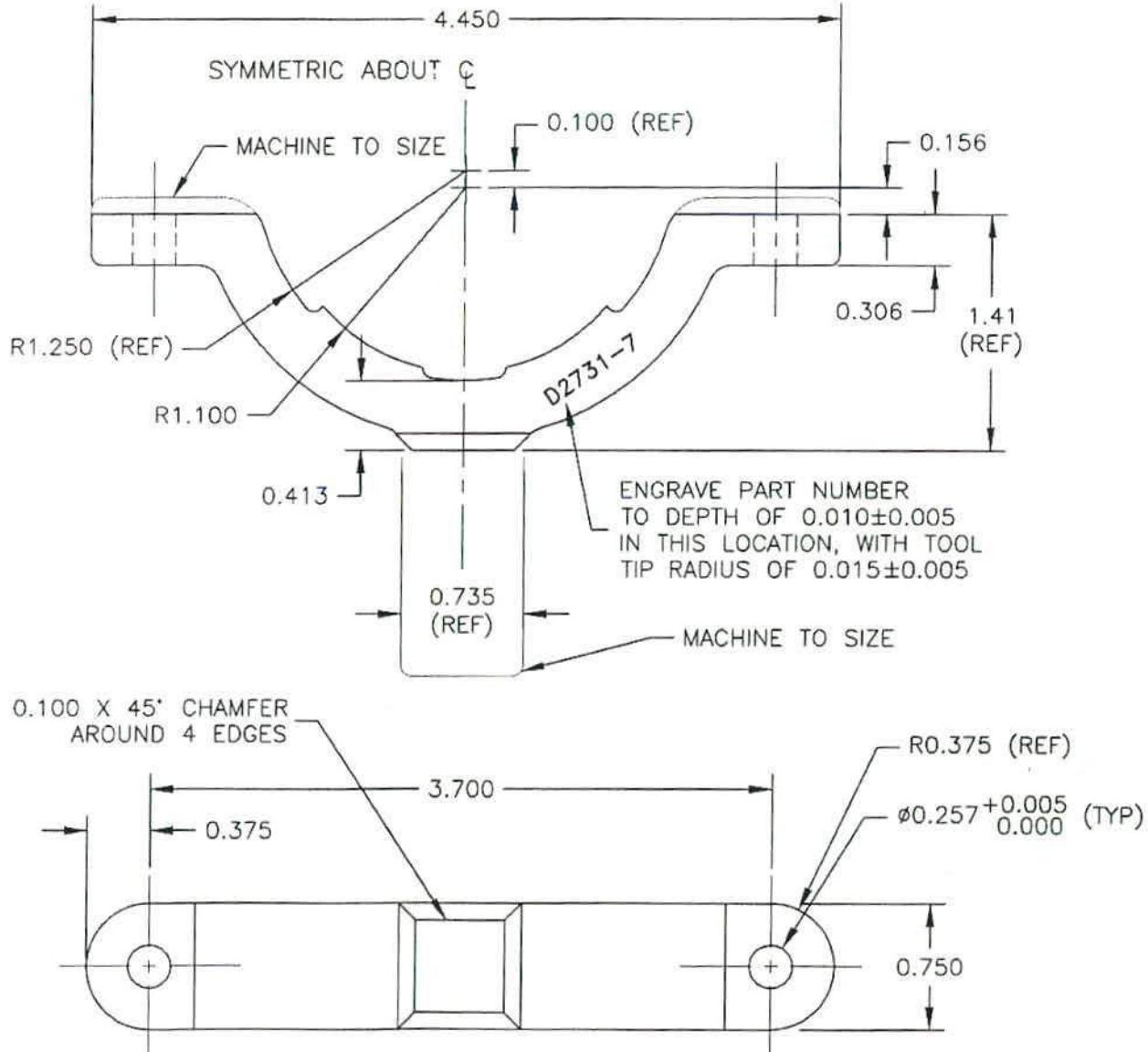
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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WITHOUT NOTICE
WORK ORDER
NO. 30995

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>CD</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30995*



METAL TECHNOLOGY INC.

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D2230-3	Lug B30993	BLKT00001
50	D2731-3	Lug B30994	BLKT00001
50	D2731-7	Lug B30995	BLKT00001
150	D3235-1	Lug B30996	BLKT00001
50	D3394-1	Lug B30997	BLKT00001
50	D3394-3	Lug B30998	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

Shig (Regula) Walz
METEC Metal Technology Inc.

Shig (Regula) Walz

Vankleek Hill, June 12, 2007

